

*Split*

Date: Wednesday, 3/14/2007 3:31:36 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 31225 -2  
Estimate Number : 10011  
P.O. Number : *NA*  
This Issue : 3/14/2007 S.O. No. : *NA*  
Prsht Rev. : NC  
First Issue : 3/14/2007 Type : LARGE FAB ASSY  
Previous Run : 29783  
Drawing Name : LUG ASSEMBLY  
Part Number : D27361  
Drawing Number : D2736 REVA  
Project Number : N/A  
Drawing Revision : A  
Material : *NA*  
Due Date : 4/6/2007 Qty: 40 Um: Each  
Written By : *[Signature]*  
Checked & Approved By : *[Signature]*  
Comment : Est Rev:D Removed from 9 digit 05-10-25 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2591 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description  
1 D2591 Lug

Batch

*031231 x 20*  
*022248 x 20*

*031231*

*FC 07 05 29*

*(40)*

2.0 D27351 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description  
1 D2735-1 Lug Bracket

Batch

*031235*  
*026003 x 15*

*FC*

*07 05 29*

*(40)*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: *M103794*

*FC 07/05/29*

*(40)*

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/05/29*

*(40)*

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/05/29*

*(40)*

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# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services  
Drawing Name: LUG ASSEMBLY

Job Number: 31225

Part Number: D27361

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*m 103 141*



*40X*

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

*BR/O.M*

*07-05-30*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*40X*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m-l*

*07/05/31*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/05/31 (40)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*40*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/01*

Job Completion

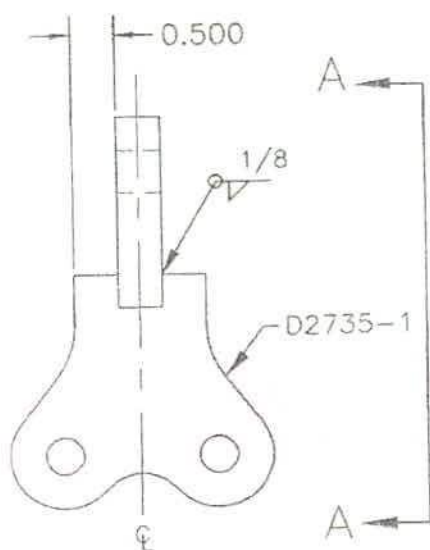


*10706-01*

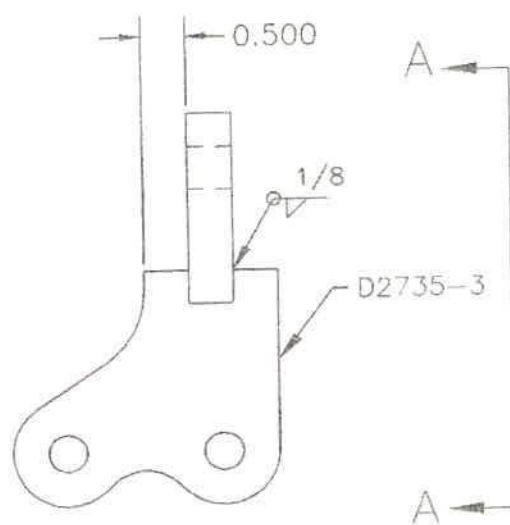
**DART**



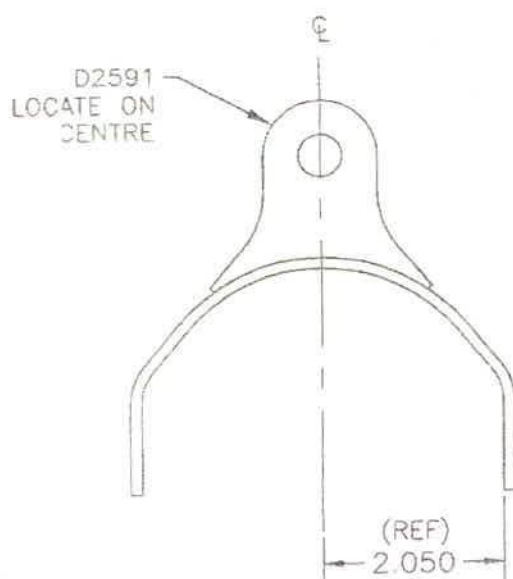
DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DMY</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

**RELEASED**  
97/12/24 D.

GEN 057

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WORK ORDER  
NO. 31225